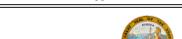
### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/Ala Rte: 80 PM: 13.2/13.9

File #: 69.28

## WELDING INSPECTION REPORT

Resident Engineer: Pursell, Gary **Report No:** WIR-007731 Address: 333 Burma Road **Date Inspected:** 03-Jul-2009

City: Oakland, CA 94607

OSM Arrival Time: 1900 **Project Name:** SAS Superstructure **OSM Departure Time:** 700 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name:** N/A **CWI Present:** Yes No **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A Yes N/A **Electrode to specification:** No Weld Procedures Followed: Yes No N/A N/A N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG** Components

### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG** Trial Assembly Area

This QA Inspector, George Goulet, randomly observed the following in the corner assemblies of segments 2AE/2BE in response to Bolting Inspection Notification Sheet No. 00059:

Section 2AE, panel points 15~16, SP+SP T-rib flange splice on 3rd and 4th T-rib from the top:

ZPMC workers performed final bolt tightening verification at the direction of ZPMC QC Inspector Hu Mei Gang (QC1) using ZPMC calibrated wrench #X02-584. No less than 10% of the ASTM A325 bolt sets at each connection were torque tested, with a minimum of one bolt set tested at each connection. QC1 provided this QA Inspector, George Goulet, with the following information regarding the bolt sets installed at this location. This QA Inspector, George Goulet, observed ZPMC's Bolt Test Log for SFOBB (RoCap list), listing the RoCap Set numbers, bolt set size, and the N.M test result for torque tightening purposes. The information presented by QC1 and listed below appeared to this QA Inspector, George Goulet, to match the RoCap list.

RC Set No. DHGM220033 – M22-2.5x65 – test result 470N.M

The torque of the above noted bolt sets were verified by torque testing with the above noted calibrated wrench

# WELDING INSPECTION REPORT

(Continued Page 2 of 2)

with the wrench setting displayed as above. This QA Inspector, George Goulet, concurred with QC1 for the issuance of green tag numbers.

This QA Inspector, George Goulet, also observed the following work in progress in the trial assembly area:

4BE/5AE joint – deck panel U-rib splice plate holes being aligned using taper pins.

4BE/5AE, panel points 28~29 – Two ZPMC welders applying overlay welds in the flat position with backing to the bottom 70mm of the south longitudinal diaphragm for the full length of the part. The part had previously been removed.

4BE/5AE, panel point 22~23 – north longitudinal diaphragm layed up after removal. No work being performed.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### **Summary of Conversations:**

As noted above and QC1 informed this QA Inspector, George Goulet, of the above noted Ro Cap bolt set numbers, bolt set sizes, locations of installation, and previously tested torque values relevant to the inspection being performed.

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Goulet,George	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer